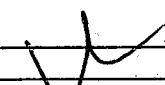
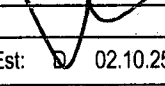


Date: Tuesday, 21/11/2006 1:42:34 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 29336	
Estimate Number : 10615	
P.O. Number : N/A	Part Number : D265623
This Issue : 21/11/2006 S.O. No. : N/A	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 29336	Material : N/A
Written By : 	Due Date : 28/11/2006 Qty: 20 Um: Each
Checked & Approved By : 	
Comment : Est: 02.10.25 Re-format KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S20GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 1.0605 sf(s)/Unit Total : 21.2100 sf(s)

1010/1025/A21/6aA SHEET

m 103258

ml 07 02 01

(20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



ml 07 02 01

(20)

(PTO)

Comment: FLOW WATER JET

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL- & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SB John

07/02/06

19

4.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-23

SB 07/02/09

(19)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/02/05	2.1	QC 2	SAD	07/02/05	20	[Signature]	07/02/05
	2.2	QC 8	[Signature]	07/02/05	20		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0702-01	2.0	Print cut by water Jet. Pressure water still coming out of tip, when tip went across the print. Machine malfunction.	[Signature] QSI012	Scrap & destroy. no replace	SB 07/02/09	0702-01	[Signature] QSI012	0702-01

NOTE: Date & initial all entries

Date: Tuesday, 21/11/2006 1:42:34 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29336

Part Number: D265623

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING
	M101601	(19x)
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 m-A/yk 07/02/09		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		(19)
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 7/02/09		
8.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP18 yk 07/02/09 X19		
9.0	QC21	FINAL INSPECTION/W/O RELEASE
		(19)
Comment: FINAL INSPECTION/W/O RELEASE 07/02/09		

Job Completion



u 07-02-09

Date: Monday, 11/6/2006 2:39:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 29336	
Estimate Number : 10615	
P.O. Number :	Part Number : D265623
This Issue : 11/6/2006 S.O. No. :	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 24846	Material :
Written By :	Due Date : 11/20/2006 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est: D 02.10.25 Re-format KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: _____

Email or ship DXF file to vendor

Laser Cut per Dwg D2656 flat pattern D2656-23

Material release note required

W2656-23

2.0	D265623F	Wearplate
-----	----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Wearplate

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Inspect dimensions per template D2656-23T1

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29336

Part Number: D265623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

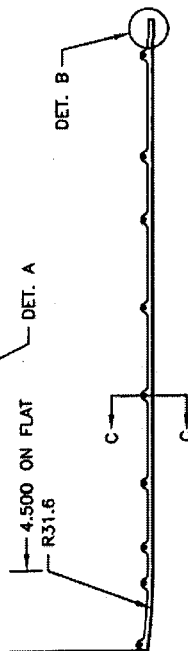
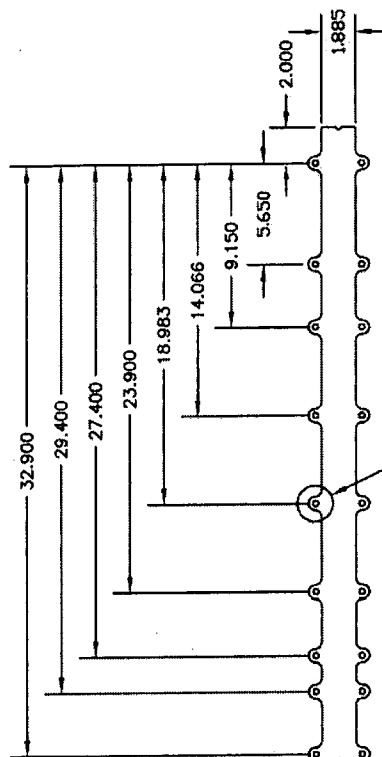
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

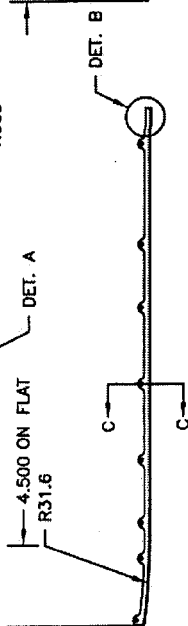
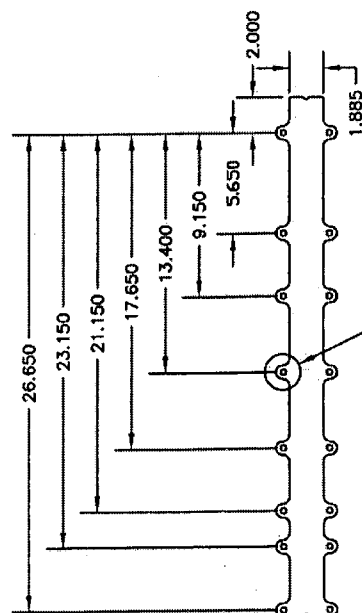


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				PORT HADLOCK, WA	
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				D2656	SHEET 1 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10
A	97:03:25			NEW ISSUE	
B	97:06:02			CHANGED TABS	
C	97:06:26			R31.6 WAS R19.5	
D	05.08.17			ENLARGE ALL HOLES TO IMPROVE FIT	

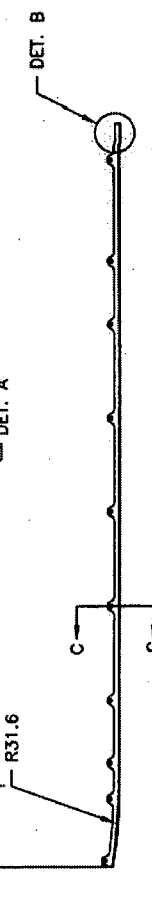
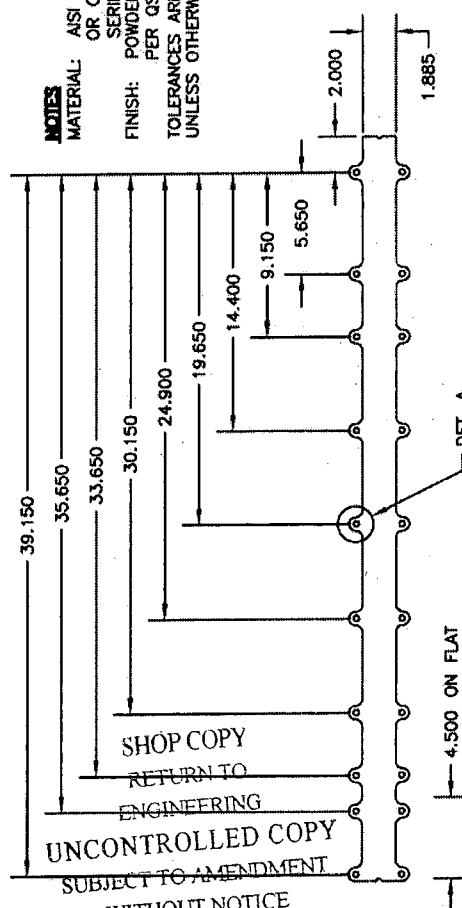
D2656-13



D2656-11



D2656-15



NOTES
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA C40-21, 39W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

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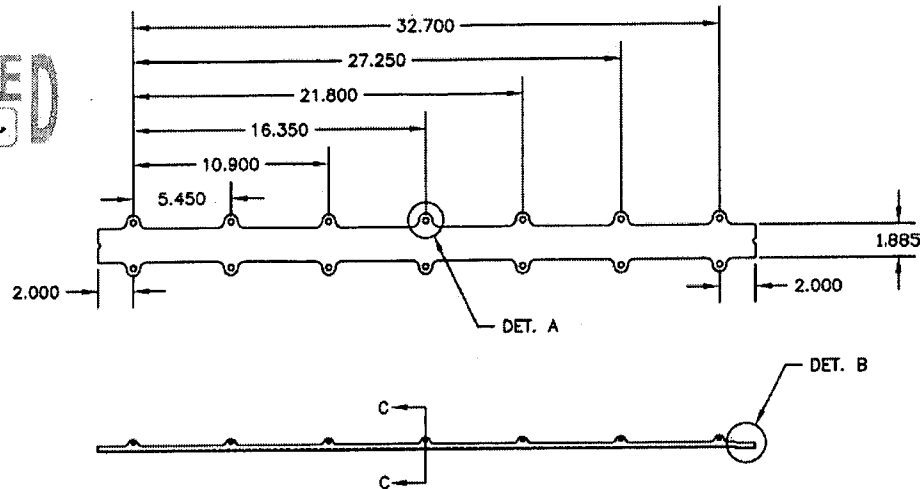
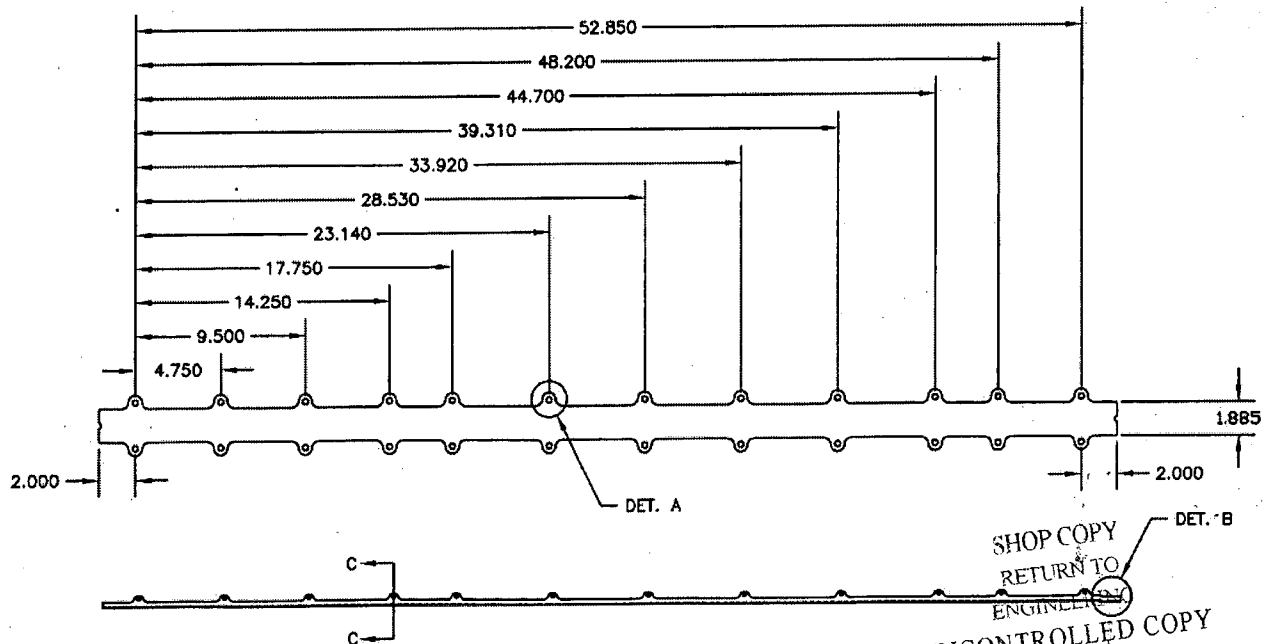
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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D2656-21**D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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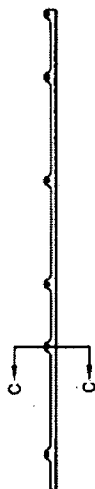
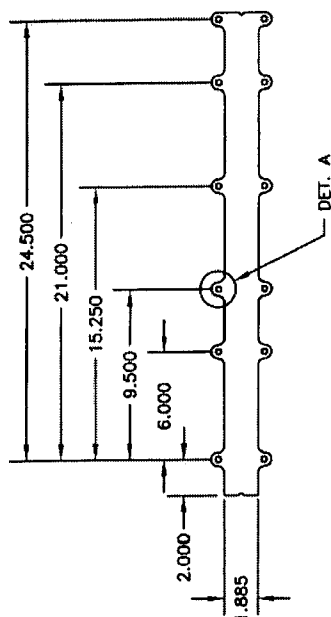
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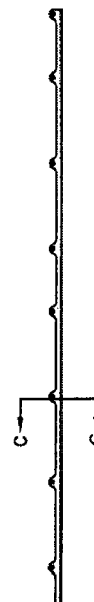
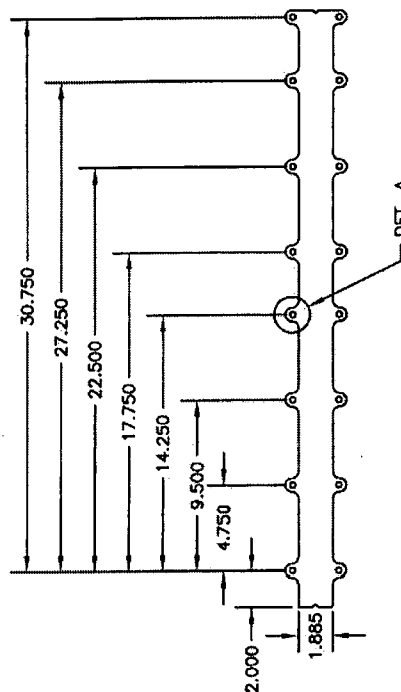


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

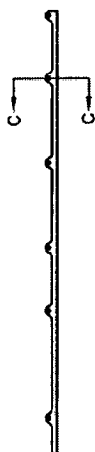
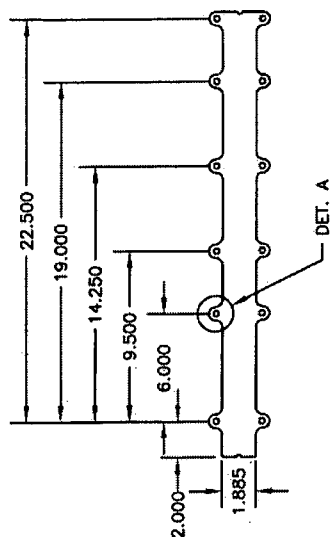


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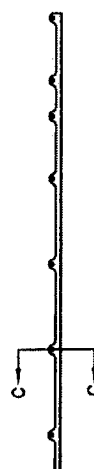
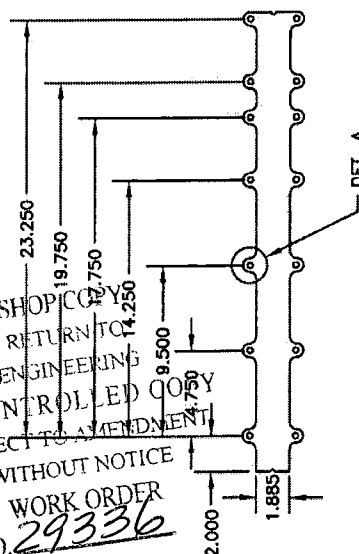
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FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005.4.3
TOLERANCES ARE PER DART QSI 018
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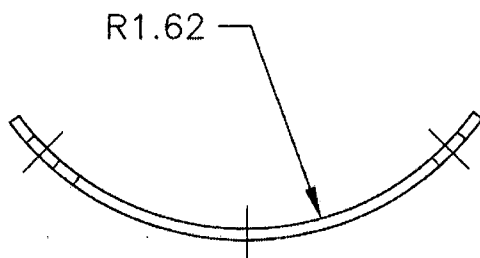
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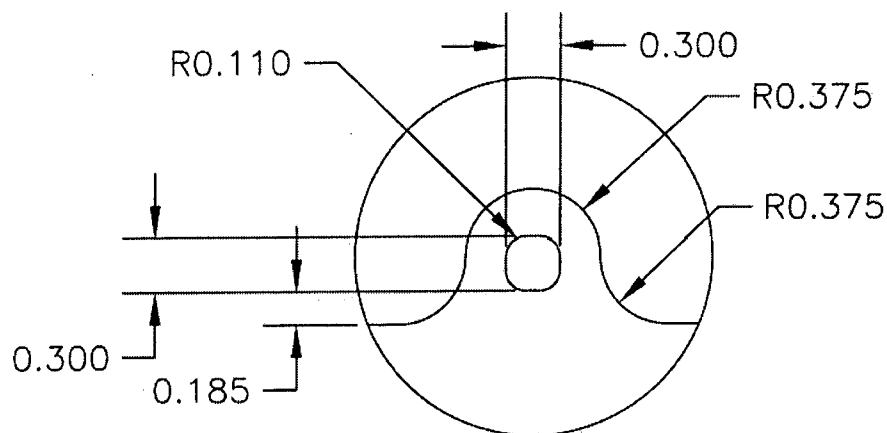
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

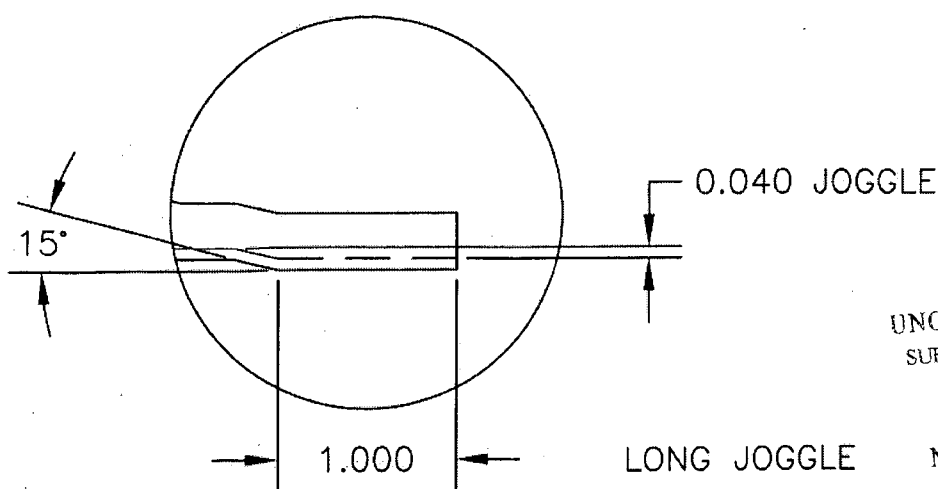


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DETAIL A



DETAIL B



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Jason Murdoch

From: S Shahbazian [sshahbazian@dartaero.com]
Sent: Thursday, January 25, 2007 8:20 AM
To: 'L Lacelle'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

I don't see problem of using .029 thicknesses instead of .036 for wearplates, unless David sees a problem.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 25, 2007 8:17 AM
To: 'S Shahbazian'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Any news on this??

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: January 23, 2007 4:51 PM
To: 'L Lacelle'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Linda,

Do we know all the variable sizes that those sheets are coming in? The decision to accept the various thicknesses is depending on where the sheets are used. For example in this case it is used for wearplates which I think it is ok; however we have to see where else it will be used. In other words depends on the application.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 23, 2007 10:48 AM
To: '*David Shepherd (*David Shepherd)'; S Shahbazian; Peter Hum (Peter Hum)
Cc: Jason Murdoch
Subject: 1010 STEEL FOR WEARPLATES

We are getting a lot of variances in tolerances on the steel mat'l we purchase for wearplates. Is there a standard tolerance for this mat'l? the 20ga we just rec'd should be about .036 – but we are getting .029 – is this acceptable. We have had this discussion before, but no one came back with a tolerance we can use to check this mat'l. Can anyone help?
LL

